













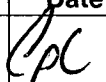



Date: Tuesday, 03/03/2009 3:41:32 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 46269		
Estimate Number	: 10746		
P.O. Number	:	Part Number	: D34633
This Issue	: 03/03/2009 S.O. No. :	Drawing Number	: D3463 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 46149	Material	:
Written By	:	Due Date	: 16/03/2009
Checked & Approved By	: <u>JUL 09.03.03</u>	Qty:	51 30' Um: Each
Comment	: EST REV. A 05.11.18 NEW ISSUE EC Est Rev:B Now on Waterjet 056-08-15 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 Sheet .063	
			
Comment: Qty.: 0.2552 sf(s)/Unit Total : 7.6545 sf(s) 304/316 .063 Sheet (m304s16ga) Batch: <u>110551</u> <u>B9-3-4</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3463 Dwg Rev: <u>B</u> <u>B 9-3-4</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>B9-3-4</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 9-3-4</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>5026364</u> (x51)			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Form Dimples as per Dwg D3463 using DT3463-3T1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3463-3 PAR #: N/A Fault Category: Prod/FAB - Ltg NCR: Yes No DQA: D Date: 09/09/03
 Resolution: re-work Disposition: re-work QA: N/C Closed: D Date: 09/09/03

NCR: <u>46269</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/29	5	Jig broke + damaged 1 part in 1st dimpled hole. Crack about 0.050" long from the edge. R.C. Process.		Fill damaged area with weld & grind flush per QSI 404.	 09-03-30	 09/09/01	 09/09/01	 09-03-30

NOTE: Date & initial all entries

Date: Tuesday, 03/03/2009 3:41:32 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46269

Part Number: D34633

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Debur

3-Form as Dwg D3463.

SB 09/04/01 (51)

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

S 02/04/01 (XSL)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(S/N)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Eric L

9/4/2

S

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/03 (A)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

09-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: 46269
Description: Step		Part Number: D3463-3
Inspection Dwg: D3463	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

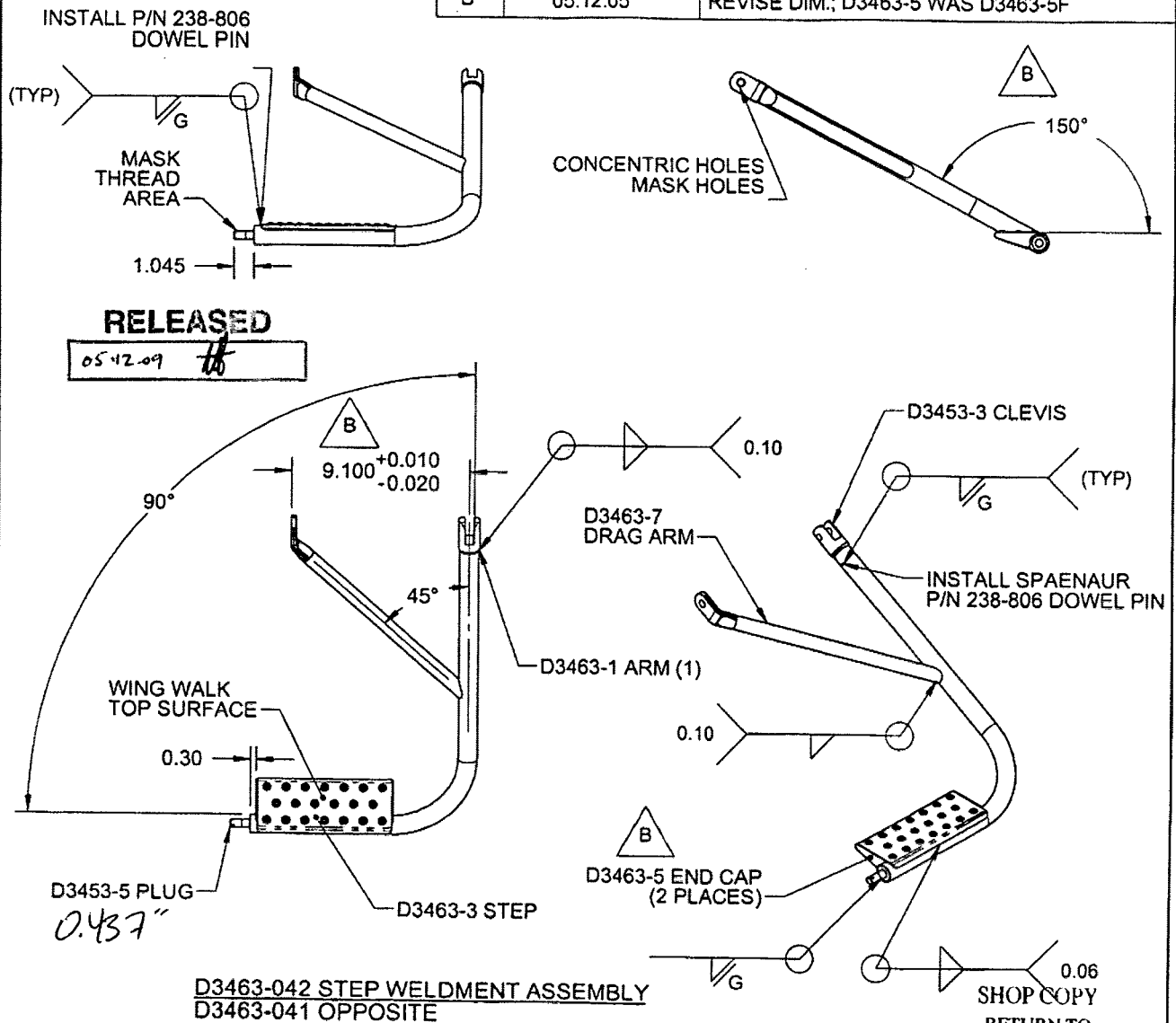
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	.192	✓			
7.00	+/-0.030	7.007	✗			
5.00	+/-0.030	5.004	✗			
6.00	+/-0.030	6.000	✓			
1.00	+/-0.030	1.00	✗			
1.750	+/-0.010	1.752	✓			
0.750	+/-0.010	.751	✗			
0.875	+/-0.010	.873	✓			
1.000	+/-0.010	1.000	✓			
0.500	+/-0.010	.500	✗			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-3-4	Date: 09/03/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	AS



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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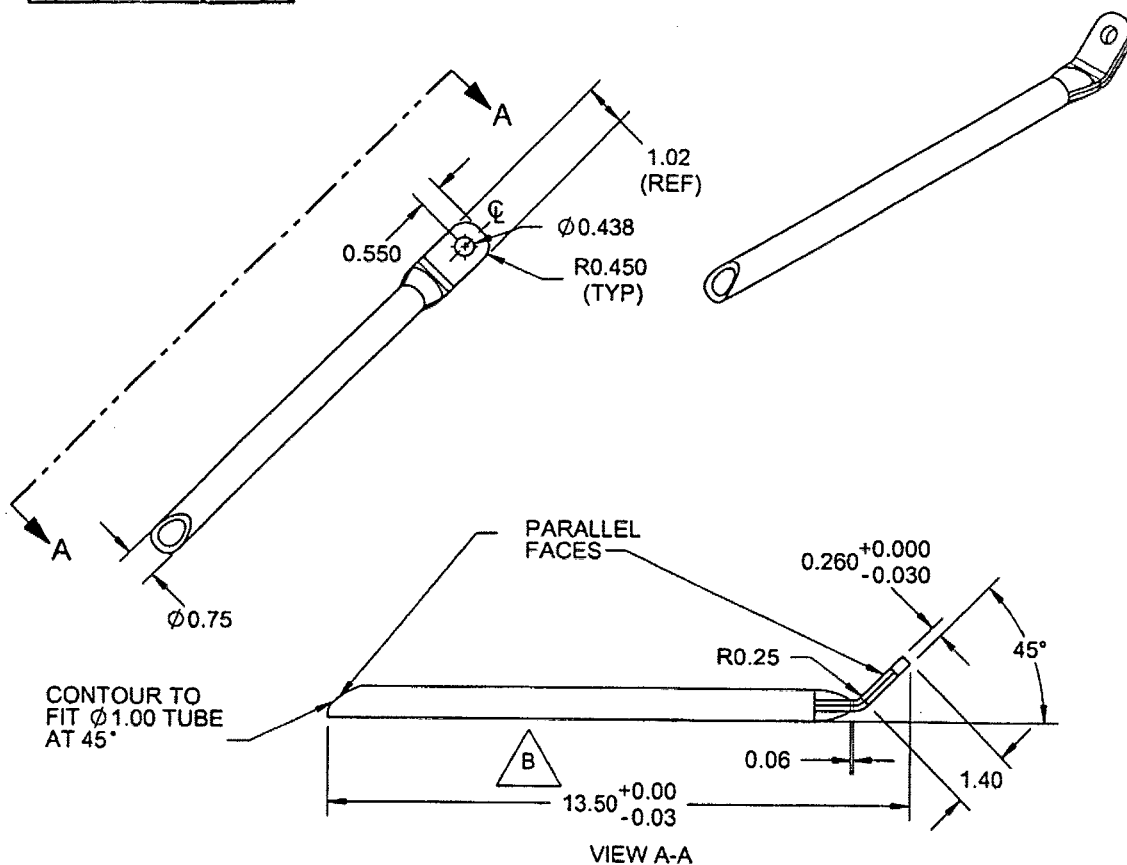
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05 #



D3463-7 DRAG ARM



NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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NO. 46209

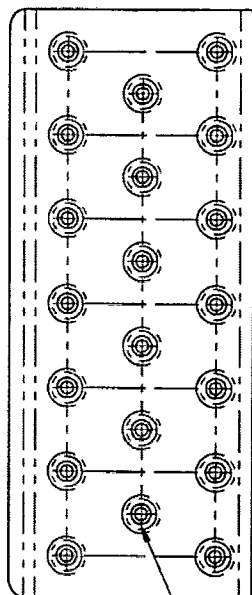
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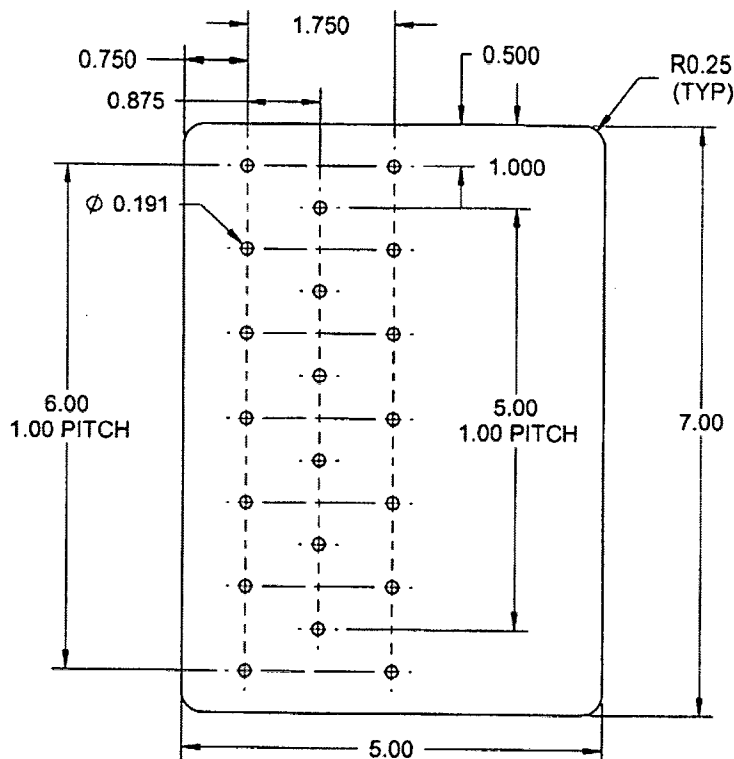
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

RELEASED

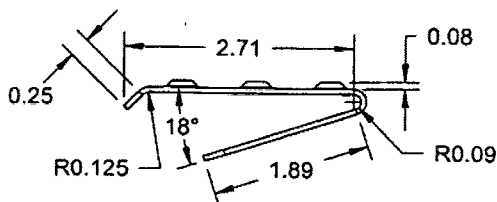
05.12.09



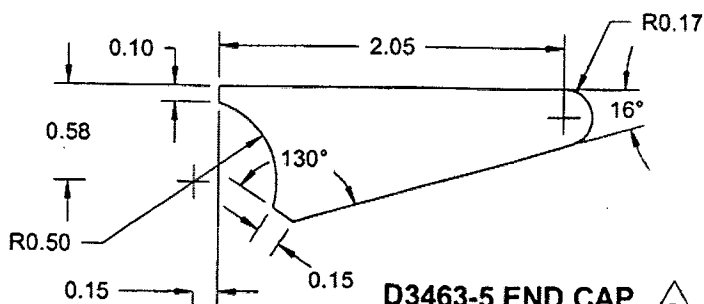
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP

SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC.)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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